

Work Order ID 56457

Wednesday, February 24, 2010 8:57:19 AM



Page 1

Item ID: D130-780-011

Accept



Setup Start



Revision ID:

Item Name: Aft LH Door Hinge

Stop



Start Date: 2/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 3/11/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *JMF*

Date: 10-2-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9502	A								
IIN-D130-780	B								

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D130-780-011
CHG 003*S1006101**H for BG 10/05/07*

110

0.00



Packaging

Pick Kit

Packaging

Memo

0.00

16-5-28 S/24

Work Order ID 56457

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Page 2

Item ID: D130-780-011

Accept



Setup Start



Revision ID:

Item Name: Aft LH Door Hinge

Stop



Start Date: 2/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 3/11/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S.0601

0.00

(2)

130



Packaging

Packaging

Memo

0.00

10-6-1 SL (2)

Identify and pack for shipping as per PPP D130-780-011

Location: 10
PPP rev: 2

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/01 AF

MF
10-6-01

Picklist Print

Wednesday, February 24, 2010 8:57:18 AM

Page 1

Work Order ID: 56457



Parent Item: D130-780-011



Parent Item Name: Aft LH Door Hinge

Start Date: 2/24/2010

Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-015		Manufactured	No			110	Each	0.0000	2.0000			
Closeout Installation			CHC7001									
D3552-13		Manufactured	No			110	Each	0.0000	2.0000			
Door Prop												
D3892-1		Manufactured	No			110	Each	94.0000	2.0000			
Seal												

Warehouse
Location

Main Warehouse

ST	94
47330	94

Warehouse
Location

Main Warehouse

ST	7
45727	1
50349	1
53043	5

→ measured 81066101
cut to 5"

D3813-041



Hinge Assembly, Upper Door

356607 10-5-28SL

356392 10-5-15P

10-5-28 SL

2

10-5-28 SL 2x

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 2/24/2010

Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
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IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3813-043		Manufactured	No			110	Each	5.0000	2.0000		10-5-28 S	



Hinge Assembly, Lower Door

Warehouse
Location

Main Warehouse

ST

Loc Qty

Loc Code

5

53044

5

D3814-1



Hinge, Upper Airframe

Manufactured

No

Warehouse
Location

Main Warehouse

ST

Loc Qty

Loc Code

5

45673

50119

5

1

4

5



10-5-28 S

2X S

Main Warehouse

ST135

50261

6

6

6

6

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Wednesday, February 24, 2010 8:57:18 AM

Page 3

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Parent Item: D130-780-011



Parent Item Name: Aft LH Door Hinge

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IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3814-3 		Manufactured	No			110	Each	17.0000	2.0000		10-5-28	

Warehouse

Location

Main Warehouse

ST	17
50120	5
50475	12

Loc Qty

Loc Code

2

10-5-28

24

D3816-1.

Manufactured No

110 Each 22.0000 4.0000

Warehouse

Location

Main Warehouse

ST	4
42077	2
45675	2

Loc Qty

Loc Code

Main Warehouse

ST115	18
52929	18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, February 24, 2010 8:57:18 AM

Page 4

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Parent Item Name: Aft LH Door Hinge

Start Date: 2/24/2010

Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3816-3		Manufactured	No			110	Each	29.0000	8.0000		10-5-28	SP

Warehouse

Location

Main Warehouse

ST	9
.45676	4
46040	5

Main Warehouse

ST133	20
52930	20

110

Each

20.0000 2.0000

D3817-041

Manufactured No

8

10-5-28

SP 28

Anchor Nut Plate

Warehouse

Location

Main Warehouse

ST	20
50381	20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Wednesday, February 24, 2010 8:57:18 AM

Page 5

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Parent Item Name: Aft LH Door Hinge

Start Date: 2/24/2010

Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/
Item Name
AN3-5A



Bolt

Replacement
Item ID

Mfg/
Purch
Purchased

Bin
Item
No

Primary
Location
No

Last
Location
110

Route
Seq ID
110

Unit of
Measure
Each

Qty on
Hand
1,431.000

Remaining
Qty To Pick
4.0000



10-5-28

SL

Date
Issued

Status

Warehouse

Location

Main Warehouse

ST	1431	
100188	188	
<u>105057</u>	1243	

AN3-7A



Bolt

Purchased

No

110 Each 97.0000 6.0000



10-5-28

SL

Warehouse

Location

Main Warehouse

ST	97	
110704	2	
111127	2	
113226	4	
113539	89	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, February 24, 2010 8:57:18 AM

Page 6

Work Order ID: 56457



Parent Item: D130-780-011



Parent Item Name: Aft LH Door Hinge

Start Date: 2/24/2010

Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310-4 ² NUT		Purchased		No		110	Each	54.0000	4.0000		1114341 10-5-28	sf

Warehouse

Location

Main Warehouse

ST	54	
112969	9	
113845	45	

Warehouse

Location

Main Warehouse

ST	58	
111499	2	
<u>112794</u>	6	4
113121	20	
113288	30	

AN4-17
BOLT

Purchased No

110	Each	58.0000	4.0000	
-----	------	---------	--------	--

10-5-28 *5/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Wednesday, February 24, 2010 8:57:18 AM

Page 7

Work Order ID: 56457



Parent Item: D130-780-011



Parent Item Name: Aft LH Door Hinge

Start Date: 2/24/2010

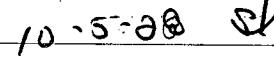
Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN970-4 		Purchased		No		110	Each	238.0000	4.0000		10-5-08 	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	238	
104885	3	
107242	3	
107715	1	
108077	2	
108377	19	
111724	3	
112082	1	
112794	9	
112991	197	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 8

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Parent Item Name: Aft LH Door Hinge

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Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3	MS1	Purchased	No			110	Each	2,560.000	10.0000		10-5-28 S	

Warehouse

Location

Main Warehouse

ST	2554	
110844	35	
111274	27	
111668	52	
112314	285	
112385	437	
113523	18	
113537	700	
113644	1000	10

Main Warehouse

ST139	6	
111668	6	

MS24665-2-12

X2

Purchased

No

COTTER PIN

Warehouse

Location

Main Warehouse

ST	130	
111499	130	4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, February 24, 2010 8:57:18 AM

Page 9

Work Order ID: 56457



Parent Item: D130-780-011



Parent Item Name: Aft LH Door Hinge

Start Date: 2/24/2010

Required Date: 3/11/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24694-S46	X3	Purchased	No			110	Each	88.0000	6.0000		10-5-28	SL

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

88

111499

88

110

Each

811.0000 16.0000

6

NAS1149D0363J X8

Purchased

No

Washer

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

811

113064

29

113288

782

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 10

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per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0463J	✓2	Purchased	No			110	Each	4,580.000	4.0000		1114576 10-5-28	SL

Warehouse

Location

Main Warehouse

ST	4580	
110914	16	
113288	57	
113524	90	
113691	2	
113706	4415	

D3622-1



Manufactured No

110 Each 37.0000 4.0000



10-5-28 SL ex

Warehouse

Location

Main Warehouse

ST	37	
55199	37	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 11

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IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3820-1 Bracket	71	Manufactured	No			110	Each	23.0000	2.0000		10-5-28	SP

Warehouse

Location

Main Warehouse

ST	23	
42079	1	
45732	22	
		2

MS21042L5

12

Purchased

No

Warehouse

Location

Main Warehouse

ST	430	
110382	10	
111636	1	
112314	16	
113523	203	Y
113537	200	

Main Warehouse

ST139	1	
112314	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 12

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Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
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IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued-	Status
NAS1149D0563J	12	Purchased	No			110	Each	2,583.000	4.0000		10-25-2010	28-03-2010

8
2
Washer

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	2583			
112794	68			
113288	50			
113524	465			
113706	2000	4		

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B
Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2			D3819-1	MALE SPADE CONNECTOR
				2			D3597-1	FEMALE SPADE CONNECTOR
				1			D3598-2-096	EXPANDABLE SLEEVE
				24			D3599-1	TIE-WRAP
				24			D3600-1	TIE-WRAP MOUNT
				24	FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
1**		1*					D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	Mounting CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
		2**	2**				D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
		2**	2**				D3538-1	HINGE BRACKET
		2**	2**				D2179	HINGE BRACKET PLATE
		4**	4**				AN526C832R24	SCREW
		4**	4**				NAS1149DN832J	WASHER
		4**	4**				MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
				1			D3983-1	OUTER CLOSEOUT
				1			D3983-3	INNER CLOSEOUT
				1			D3983-5	HINGE CLOSEOUT
				1			D3983-047	CLOSEOUT ATTACHMENT
				1			D3983-9	SPACER
				2			AN525-10R6	SCREW
				1			AN525-10R24	SCREW
				1			NAS1149D0363J	WASHER
				1			MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY
REF. EASA. IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-13	DOOR PROP

WAS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	D. SHEPHERD (DE # 02)
DATE:	10.02.03
CERT. NO.:	SH93-88
ISSUE NO.:	6

A	NEW ISSUE	REV.	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN			10.02.03
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	10.02.03		
DART AEROSPACE LTD			
HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. A	
DSI 9502		SHEET 1 OF 1	
TITLE		SCALE	
REPLACEMENT DOOR PROP		NTS	
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